

Date: Monday, 27/10/2008 8:03:09 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADAPTER
Job Number	: 42969		
Estimate Number	: 13305		
P.O. Number	:	Part Number	: D37731
This Issue	: 27/10/2008 S.O. No. :	Drawing Number	: D3773 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 40996	Material	:
Written By	: <u>27/08.10.27</u>	Due Date	: 03/11/2008 Qty: 30 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 08-05-07 JLM Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B1500X1500	304 bar 1.50 X1.50
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Comment: Qty.: 0.2363 f(s)/Unit Total : 7.0875 f(s)
M304B1.5"X1.5"
BATCH: 107979

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank 2.700" long

H.A 08/10/31

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1 HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA740 Rev. AA & Dwg D3773 Rev. B

2-Deburr per dwg D3773

88 08/11/01

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

88 08/11/01

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/11/03

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 42969

Part Number: D37731

Job Number:



Seq. #:

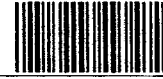
Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST245

JS 08/11/04

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

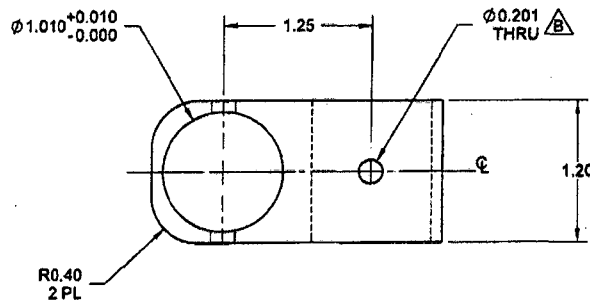
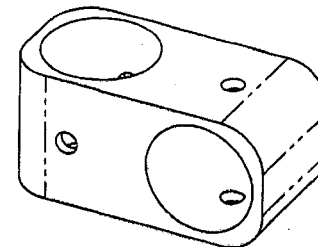
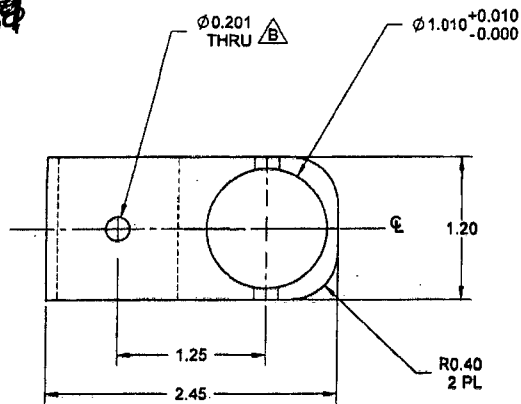
08/11/05

Job Completion



MF 08-11-04

w/o 42968



D3773-1 ADAPTER

RELEASED
06-07-10 MJD


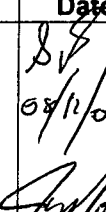




- NOTES:
- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
DATE	08.06.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS NOTED PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/10/01	3.0	Need a First Article Inspection checklist with the W/O	Sir	08/01/01				

Part No: D3773-1 PAR #: N/A Fault Category: Prod/Manufact NCR: Yes No DQA: S Date: 08/12/09
D3773-041 D3782-045 D412-769-043/044 QA: N/C Closed: D Date: 08/12/09

NCR: 42969		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/01	3.0	One part come out of the first operation. R.C. On last shift the setup was done and the part was in the middle of the Vise. Not correctly placed. R.C: The how/where to position was not specified in the folio.		Scrap: replace Qty 1 See attached.	 08/11/01	 08/12/08	 08/12/08	 08/12/08
								

NOTE: Date & initial all entries

G54:

X=0.0 CORNER

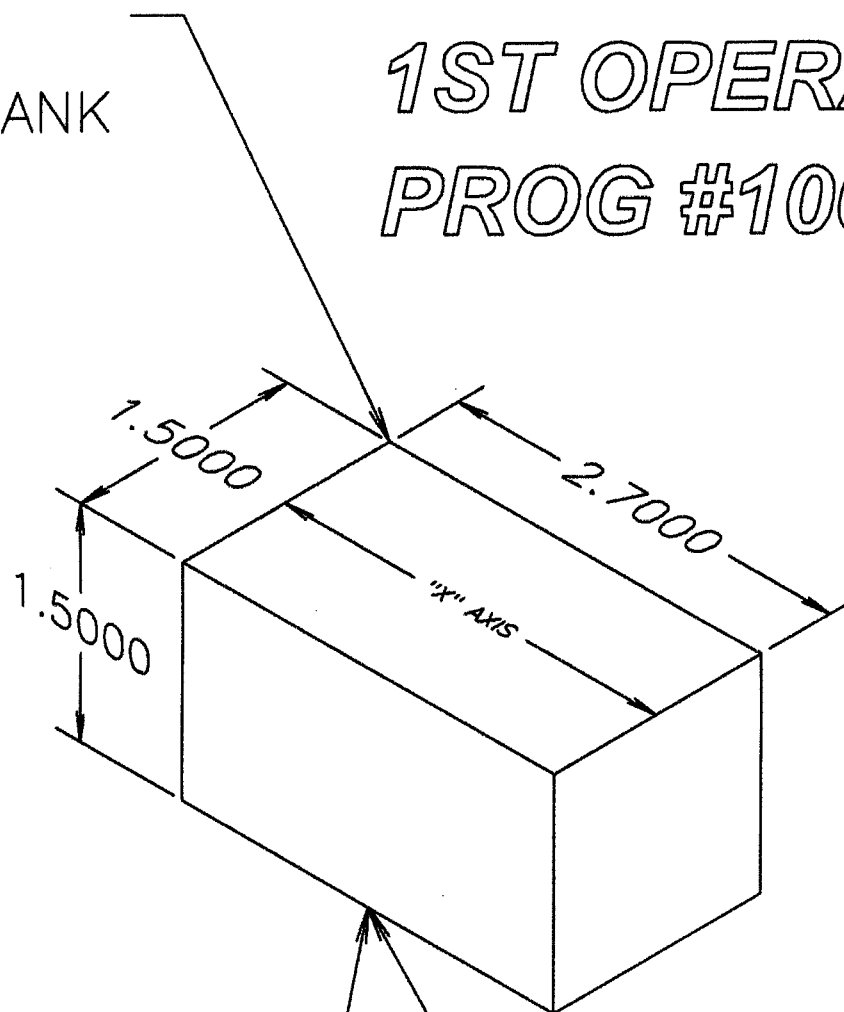
Y=0.0 CORNER

Z=0.0 TOP OF BLANK

D3773-1 ADAPTER

1ST OPERATION

PROG #1000

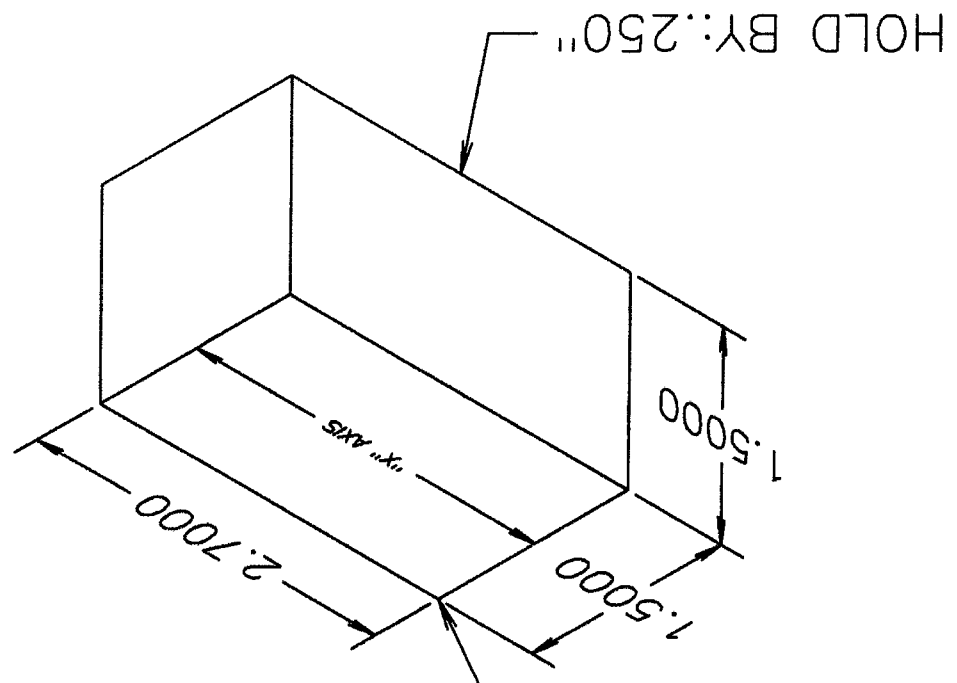


HOLD BY:.250"

HOLD IN CENTER OF VISE

D3773-1 ADAPTER
1ST OPERATION
PROG #1000

old



G54:
X=0.0 CORNER
Y=0.0 CORNER
Z=0.0 TOP OF BLANK